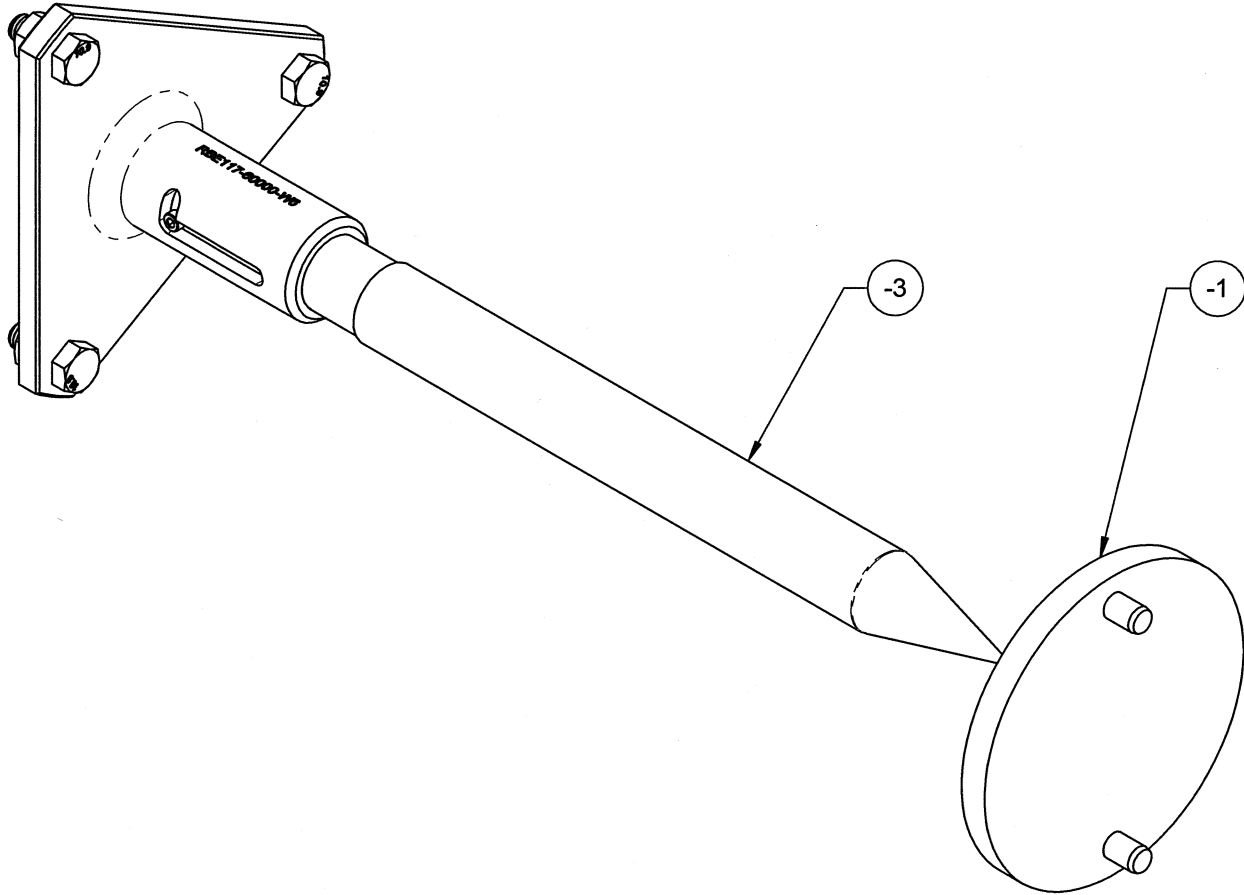


ITEM #	QTY	PART #	PART TITLE
-1	1	RBE117-60000-W6-1	DISK ASSEMBLY
-3	1	RBE117-60000-W6-3	POINTER ASSY



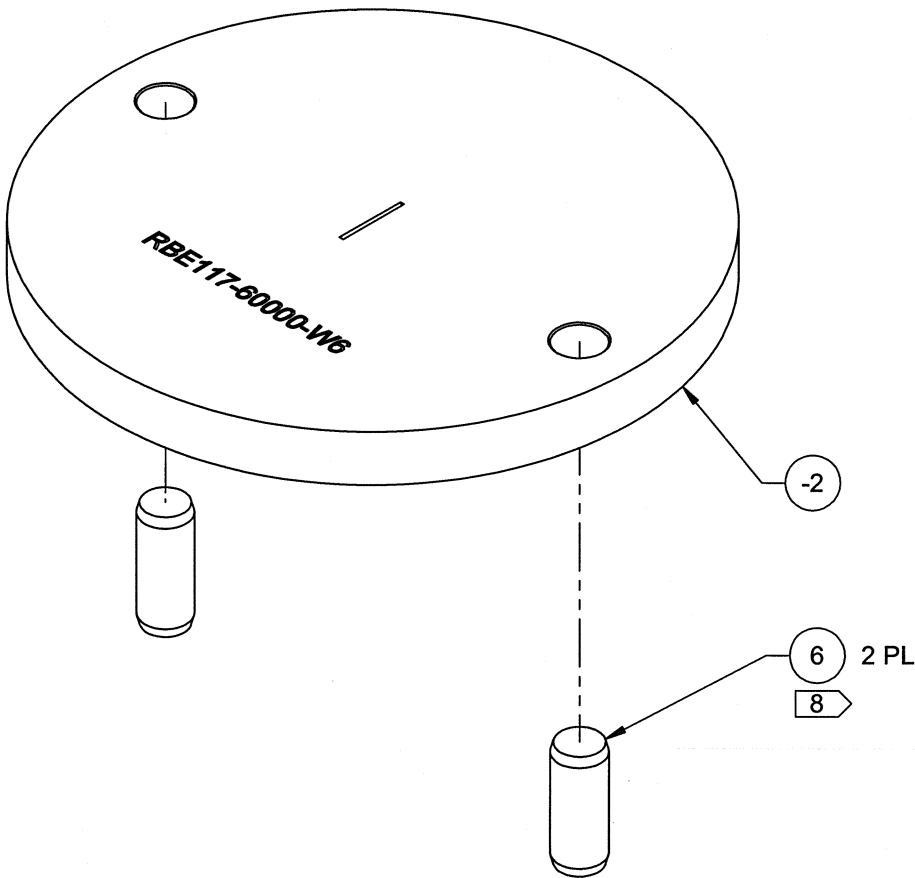
**RBE117-60000-W6 ALIGNMENT DEVICE**

7

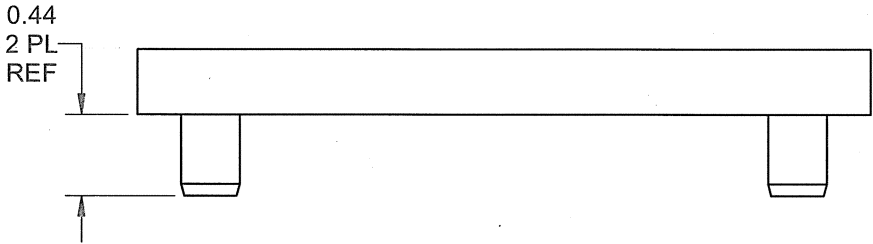
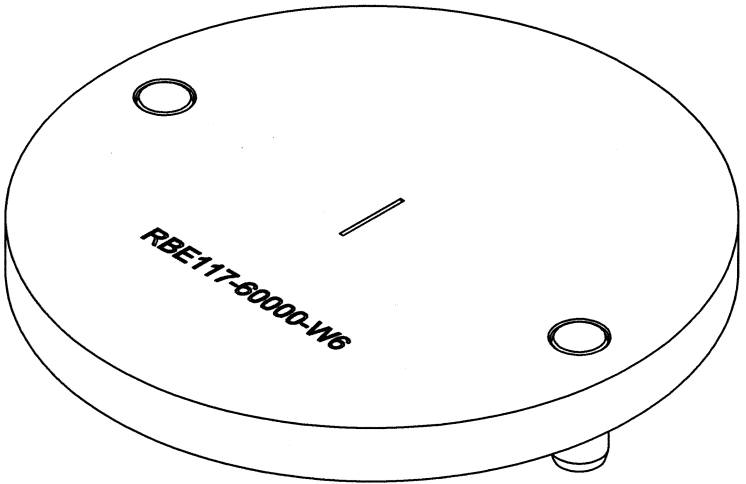
- NOTES:
- 1) MATERIAL: N/A
  - 2) HEAT TREAT: N/A
  - 3) FINISH:
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) IDENTIFICATION: N/A
  - 7) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

A	NEW ISSUE	19-747	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	RBE117-60000-W6	SHEET 1 OF 6
APPROVED	VM	TITLE	SCALE
		ALIGNMENT DEVICE	NTS
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ITEM #	QTY	PART #	PART TITLE
-2	1	RBE117-60000-W6-2	DISK
6	2	McMaster#93600A697 OR EQUIV	SS316 DOWEL PIN 8mm DIA. X 20mm LG.

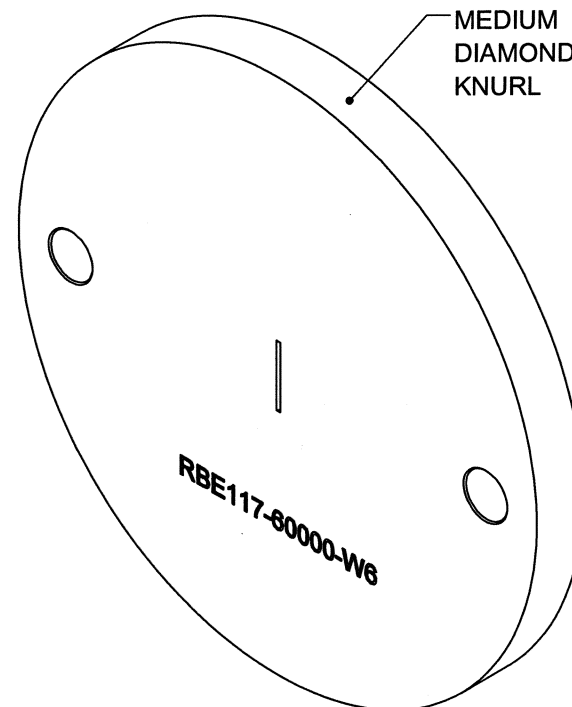
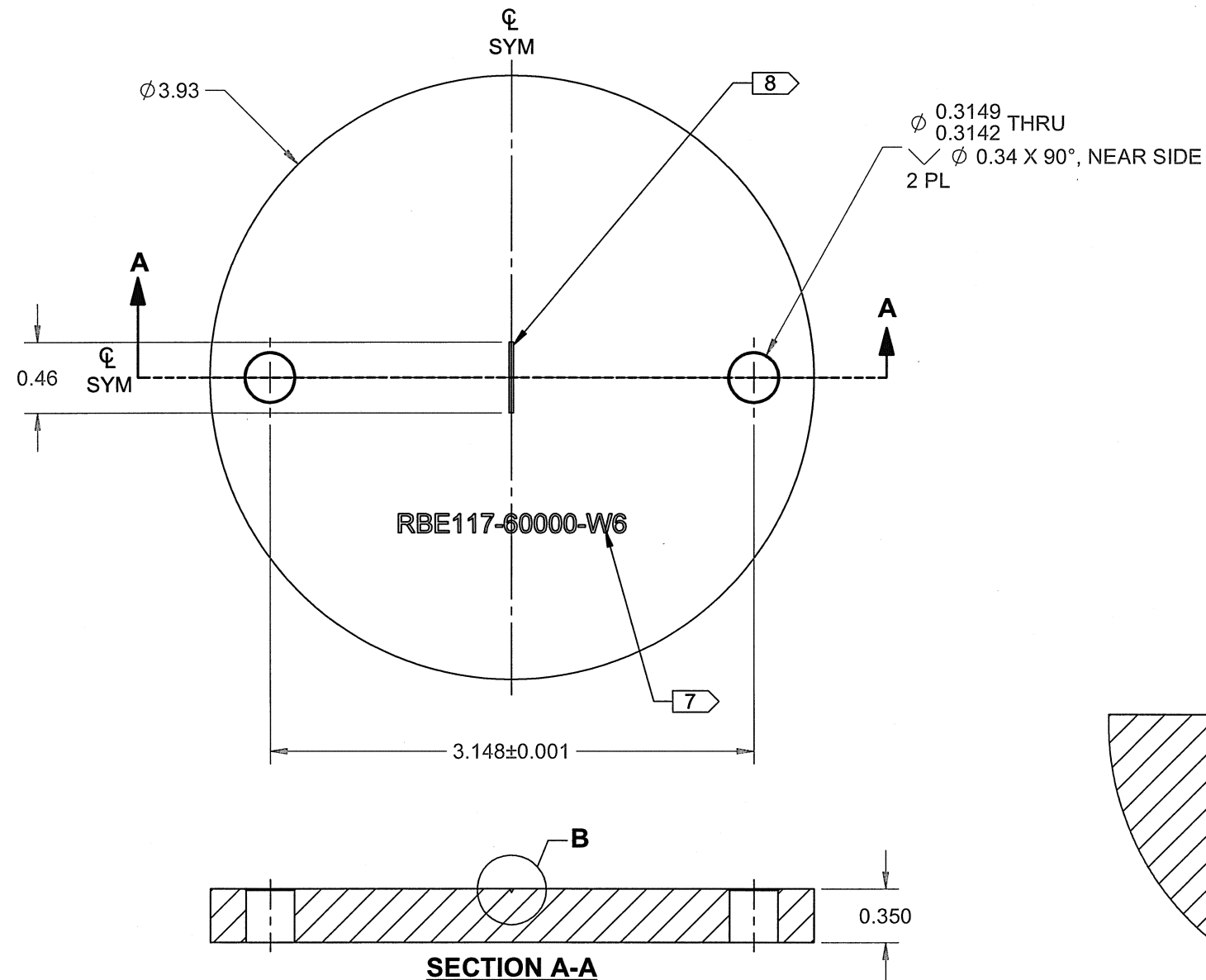


**RBE117-60000-W6-1 DISK ASSEMBLY**



NOTES:  
1) MATERIAL: N/A  
2) HEAT TREAT: N/A  
3) FINISH:  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) IDENTIFICATION: N/A  
7) ASSEMBLE AS SHOWN  
8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES  
THEN PRESS FIT ITEM 6 FLUSH TO SURFACE OF ITEM -2 AS SHOWN, AND REMOVE EXCESS

DESIGN	VM	<b>DART AEROSPACE LTD</b>	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	<b>RBE117-60000-W6</b>	SHEET 2 OF 6
APPROVED		TITLE	SCALE
		<b>ALIGNMENT DEVICE</b>	NTS
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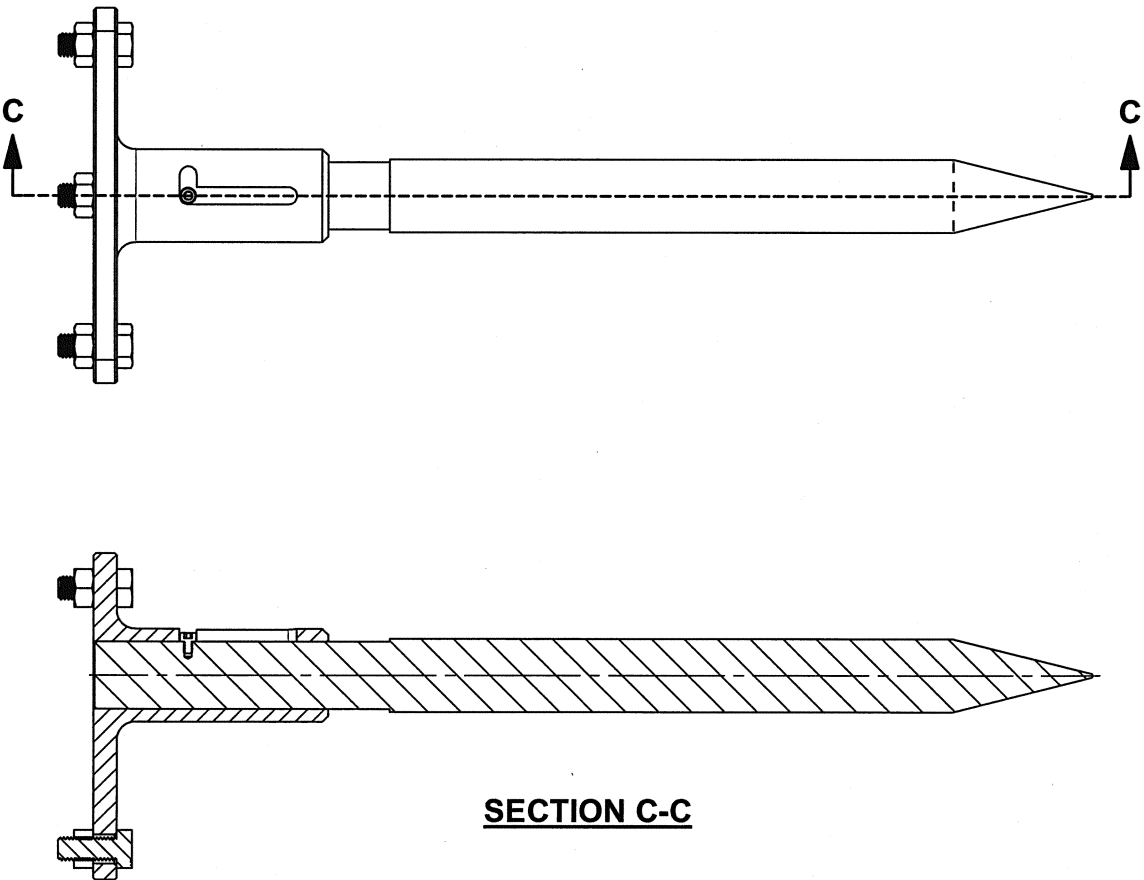
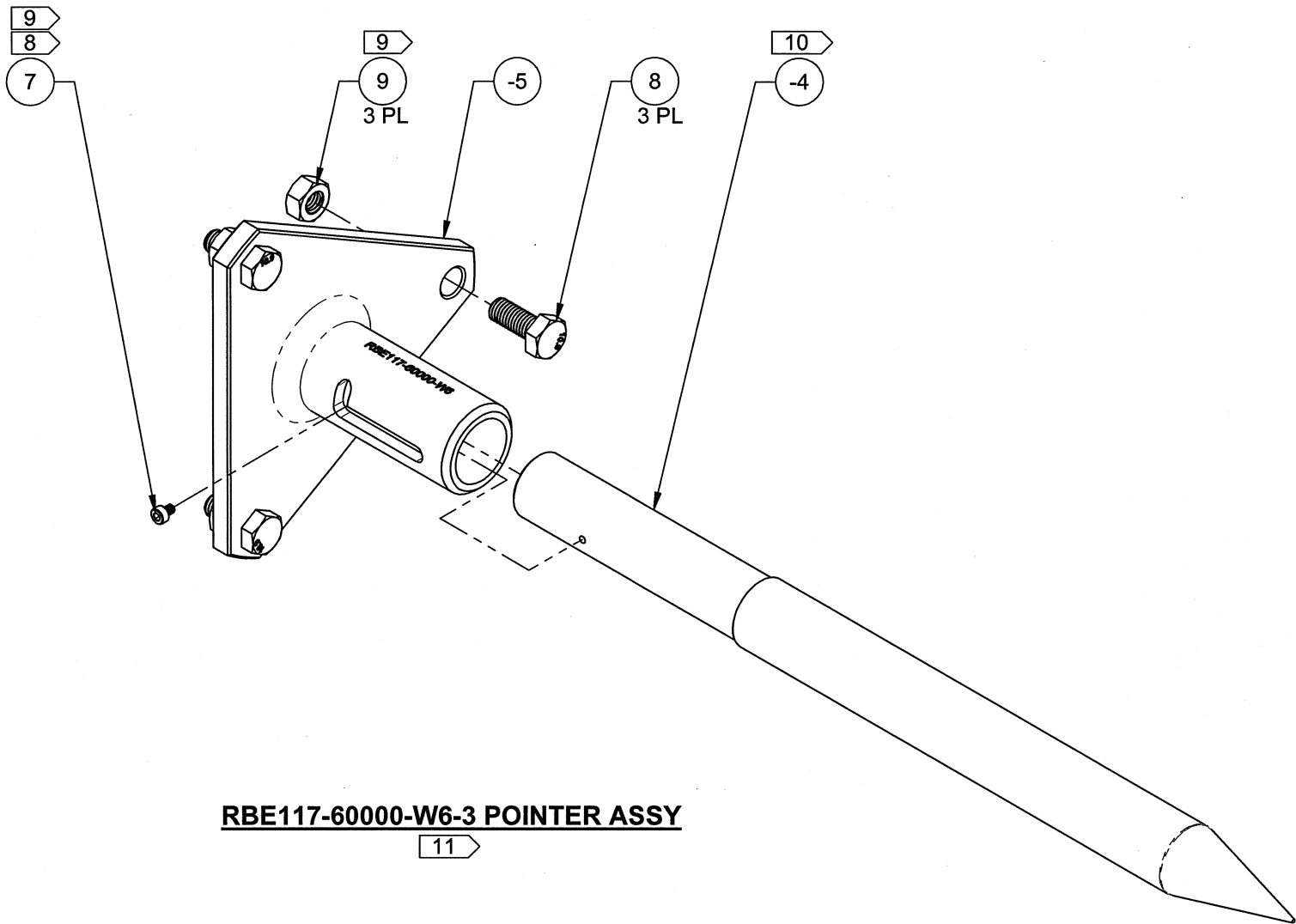
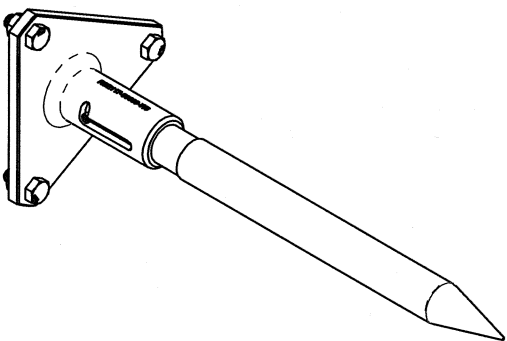


**RBE117-60000-W6-2 DISK**

- NOTES:
- 1) MATERIAL: 6061-T6 / 7075-T6
  - 2) HEAT TREAT: N/A
  - 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) REMOVE ALL SHARP EDGES AND BURRS
  - 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RBE117-60000-W6", AS SHOWN
  - 8) SCRIBE LINE NEED TO BE FILLED WITH BLACK INK

DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	<b>RBE117-60000-W6</b>	SHEET 3 OF 6
APPROVED	WJP	TITLE	SCALE
		<b>ALIGNMENT DEVICE</b>	NTS
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ITEM #	QTY	PART #	PART TITLE
-4	1	RBE117-60000-W6-4	POINTER
-5	1	RBE117-60000-W6-5	BASE
7	1	McMaster#92290A108 OR EQUIV	SS316 SOCKET HEAD SCREW M3 X 0.5mm X 4mm LG.
8	3	McMaster#90854A164 OR EQUIV	ZINC YELLOW PLATED GRADE 10.5 STEEL HEX HEAD SCREW M8 X 1.25mm X 20mm LG.
9	3	McMaster#92497A400 OR EQUIV.	ZINC YELLOW PLATED GRADE 10 STEEL HEX NUT M8 X 1.25mm X 6.5mm HT.

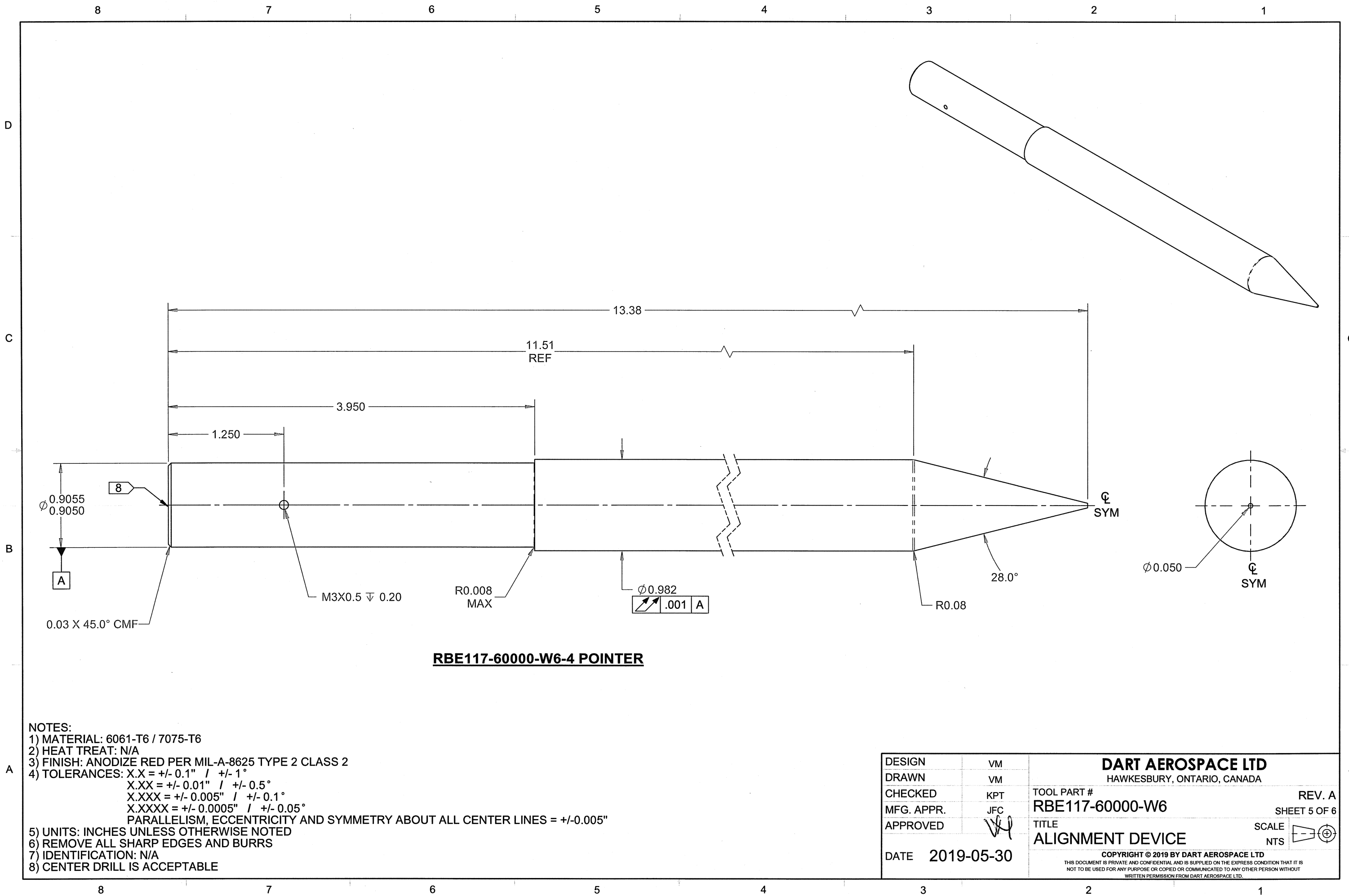


**RBE117-60000-W6-3 POINTER ASSY**

**SECTION C-C**

- NOTES:
- 1) MATERIAL: N/A
  - 2) HEAT TREAT: N/A
  - 3) FINISH: N/A
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) IDENTIFICATION: N/A
  - 7) ASSEMBLE AS SHOWN
  - 8) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 7 THEN ASSEMBLE WITH ITEM -4, AND REMOVE EXCESS
  - 9) INSTALL ITEM 7 AND ITEM 9 HAND TIGHT
  - 10) ITEM -4 MUST SLIDE FREELY ALONG ITEM -5
  - 11) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	VM	<b>DART AEROSPACE LTD</b>	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	<b>RBE117-60000-W6</b>	SHEET 4 OF 6
APPROVED		TITLE	SCALE
		<b>ALIGNMENT DEVICE</b>	NTS
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**RBE117-60000-W6-4 POINTER**

- NOTES:
- 1) MATERIAL: 6061-T6 / 7075-T6
  - 2) HEAT TREAT: N/A
  - 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) REMOVE ALL SHARP EDGES AND BURRS
  - 7) IDENTIFICATION: N/A
  - 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	<b>RBE117-60000-W6</b>	SHEET 5 OF 6
APPROVED		TITLE	SCALE
		<b>ALIGNMENT DEVICE</b>	NTS
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